

Date: Wednesday, 23/07/2008 3:06:08 PM

User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 40734

Estimate Number : 13298

P.O. Number :

This Issue : 23/07/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Previous Run : 39036

Written By :

Checked & Approved By :

Comment :

Est Rev:A 08-05-01 new issue DD verified by:EC

Est Rev:B 08-07-22 revB as per dwg DD verified by:EC

Drawing Name : SUPPORTING PLATE

Part Number : D37811

Drawing Number : D3781 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 30/07/2008

Qty: 3 Um: Each

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M0001T03000-11204T35080 6061-T6 .080 Sheet



Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s)

6061-T6 .080 Sheet

batch: 107460 IB 8-7-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3781-1

Dwg Rev: PRE-L

Prog Rev: PRE-L

*****grain direction along 3.61" *****

2- Deburr if necessary

IB 8-7-24



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-7-24

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/07/24 (14)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3781

IB 08/07/25

(3)

PRELIMINARY ISSUE

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 40734

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-counter sink holes as per dwg D3781

CP 08/07/28 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/28 (X3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

2 V/BR 08/07/28 (X2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fix 08/07/28 (3)

10.0

MS20426AD34

RIVET



Comment: Qty.: 10.0000 Each(s)/Unit Total : 100.0000 Each(s)

RIVET

batch: *105978*

SP

11.0

MS21075L3

Nutplate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 50.0000 Each(s)

Nutplate

batch: *M108757*

8/1/29 SP

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- assemble nut plate as per dwg D3781

CP 08/07/29 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

h2000 S 08/07/29 (X3)

**ENGINEERING
APPROVAL**

**ABBROVIT
ENGINEERING**

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 40734

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Stores 119

*Leadz/Chizeta 1 2 sent to 1
402 key*

8/2/29 ax 54

MF 08-07-29

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



POSITIVE RECALL

EFFECTIVE *08-28-03* AUTH *LI*

RELEASED *4/2* DATE *09.02.17*

EFFE

RELE

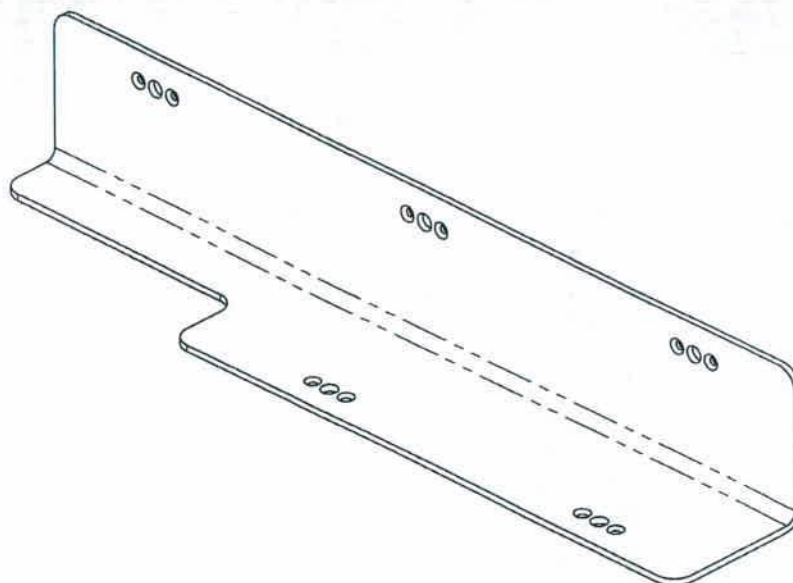
09.02.17

MF 08-07-29

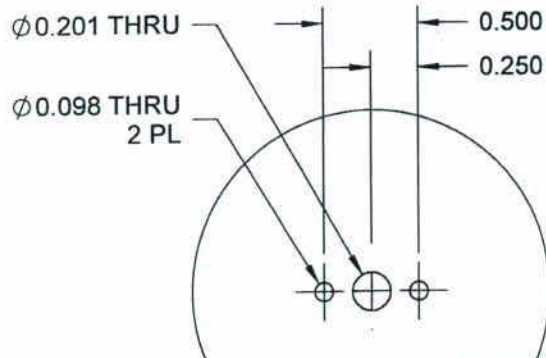
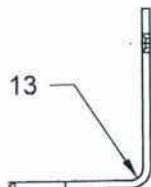
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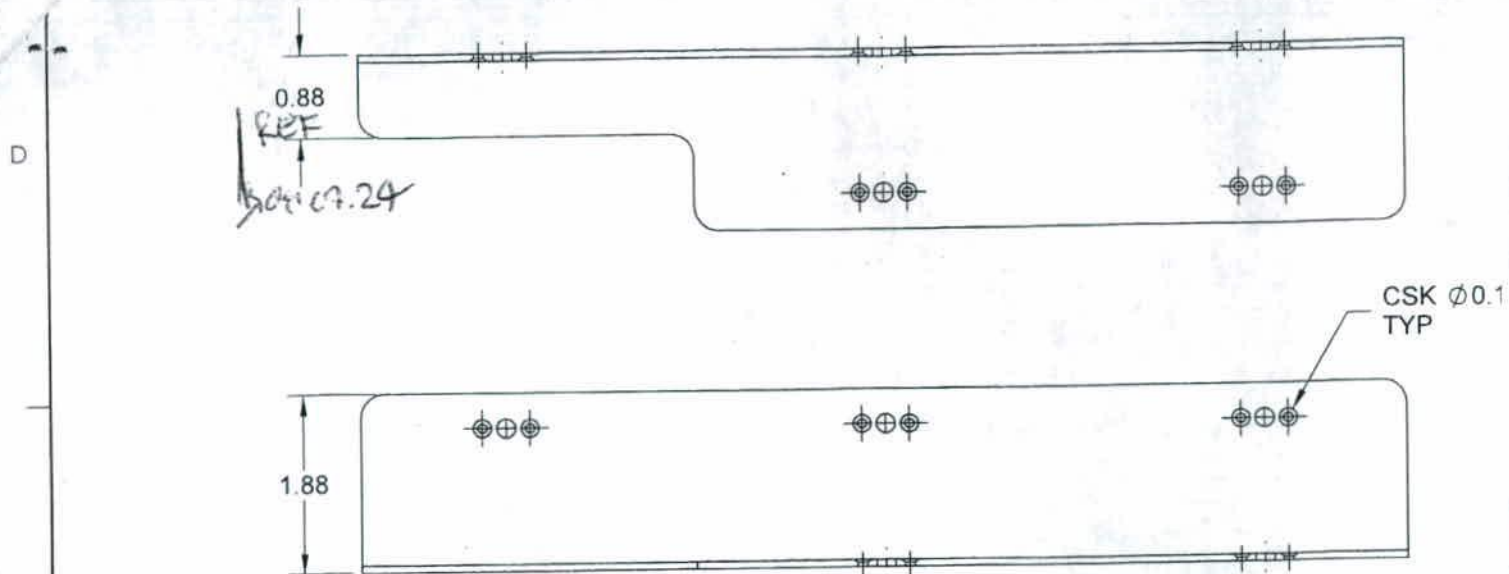


DETAIL B
SCALE 2X, 5 PL

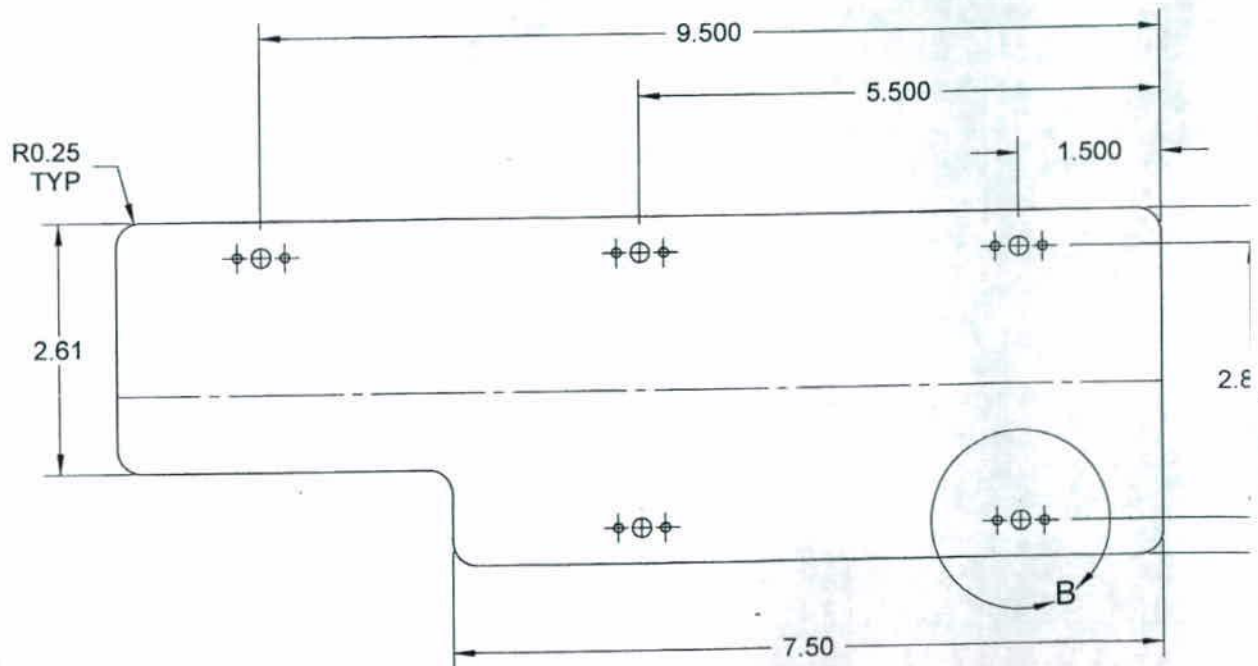
PRELIMINARY ISSUE

08.07.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F

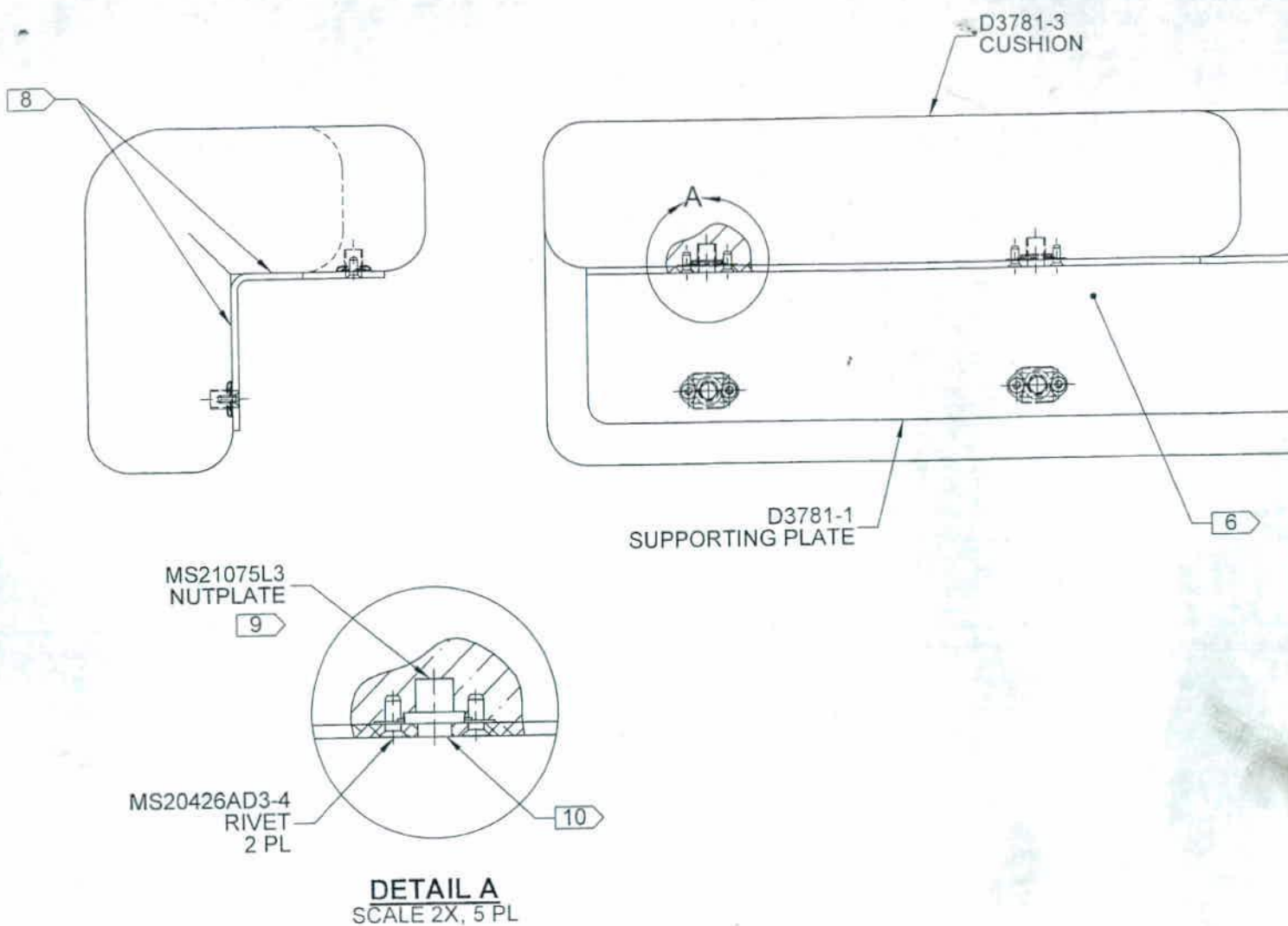


D3781-1F FLAT PATTERN

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

WLO
40734



D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.00 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

Wednesday, 23/07/2008 3:06:08 PM

User: Linda Lacelle

Process Sheet

Split u/b
80 08/07/25

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40734
Estimate Number : 13298

Drawing Name : SUPPORTING PLATE

P.O. Number :
This Issue : 23/07/2008 S.O. No. :

Part Number : D37811
Drawing Number : D3781 PRELIM

Prsht Rev. : NC
First Issue : 11 Type : SMALL / MED FAB

Project Number : N/A
Drawing Revision : PRELIM

Previous Run : 39036

Material :
Due Date : 30/07/2008

Qty: 3 Um: Each

Written By : Checked & Approved By : 

Comment : Est Rev:A 08-05-01 new issue DD verified by:EC
Est Rev:B 08-07-22 revB as per dwg DD verified by:EC

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2896 sf(s)/Unit Total: 2.8959 sf(s)

6061-T6 .080 Sheet

batch: 107460

IB 8-7-23

PD 5859

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3781-1

Dwg Rev: PRE-L

Prog Rev: PRE-L

*****grain direction along 3.61" *****

2- Deburr if necessary

IB 8-7-24



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3781

IB 08/07/25

(3)

1870

Receiving Report

Date: 8/3/18
Supplier: CAMP

Batch No: M107460
Dart P/O: 5857

Packing Slip: Yes ✓ No ✓
Invoice: Yes ✓ No ✓
Receipt: Cash ✓ Cr ✓

Release Note Attached: Yes ✓ No ✓ N/A ✓
Waybill Attached: Yes ✓ No ✓ N/A ✓
Shipment Complete: Yes ✓ No ✓ N/A ✓
QC6 Inspection 500-3/180 N/A ✓
Work Order N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 08/03/20
Date: RCP 7381
Received/Costing: 62
Initial:

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

77-4248
77-5696

MONTREAL: 514 336-4248
FAX: 514 336-4246

ONTARIO: 1 800 667-4248
FAX: 1 866 456-4242

SHIP TO:

PAGE LTD
KEEN STREET

On a du Sauter "738"

DE: TROUPEUR ET MONTAUX SPECIALISES
1111 AUBURN CANTONAL DISTRIBUTION

DATE: N°:
BON DE LIVRAISON N°:
PACKING SLIP:
DATE DE LIVRAISON:
DELIVERY DATE:

TERMS / TERMS: TERR: REMARQUES / REMARKS:
NET 30 JOURS: 233

DESCRIPTION	POIDS WEIGHT	PRX PRICE	UNIT #	MONTANT AMOUNT
080 4' X 12'	3	876.000		2628.000
X 144				
X 3/4 X 249	100	2.500		250.000
HARDE	1	3.200		3.200
POIDS TOTAL	104			
TOTAL WEIGHT	104			

RECEIVED

62

ALLS BEHOLD THE PROPERTY OF: AGER CAMP INC. UNIT. INVENT IS MADE IN FULL COMPLETE AND DANGEROUS. IF BUYERS EXPIRE. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. RESPECT THE FOLLOWING CONDITIONS: LET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY IN ADVANCE ON 20% PAY ADVANCE ON ALL INVOICE DATES. ANY DEFECTS IN RECEIPT WITHIN 10 DAYS OF ACCEPTATION AND RETURNS TO THE SELLER AT HIS CHOICE TO CLAIM FOR THE DAMAGE OR ON THE SELLER. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANDISE ON RECEIPT CANNOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ONE PRICE.
N BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION
N/Y M/M J/D
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SHIP TO:
SOLD TO:

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4073190

CUSTOMER PO NUMBER: N18692	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP UNLOAD ID: 100769/6	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1038947	LINE ITEM: 6	SHIP DATE: 10-AUG-2006	ALLOY: 2024	CLAD: BARE
			TEMPER: T3	PRODUCT DESCRIPTION: KAISER STRETCH
WEIGHT SHIPPED: 4317 LB	QUANTITY: 76 PCS EST.	B/L NUMBER: 209286	GAUGE: 0.0800 IN	WIDTH: 48.000 IN
				LENGTH: 144.000 IN

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 368375A2 Cast 340

Drop 33

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.7 : 87.1 (480 : 463)	45.6 : 45.6 (314 : 314)	19.0 : 19.6

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.23	4.53	0.60	1.37	0.01	0.17	0.02	0.01	0.01	TOT 0.06

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREON. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO 9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy

WATER SUPPLY

WATER SUPPLY

WATER SUPPLY

WATER SUPPLY

WATER SUPPLY

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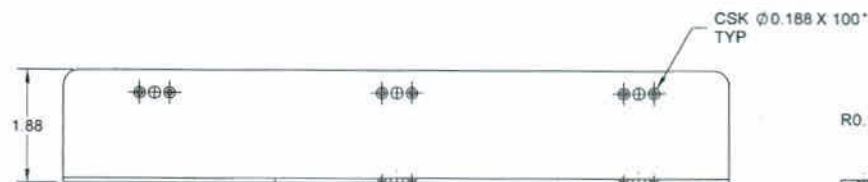
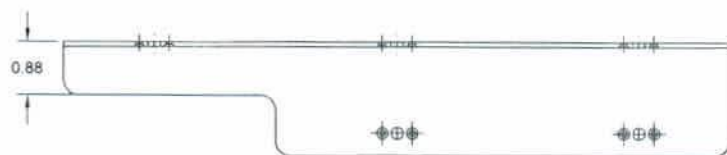
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WATER SUPPLY

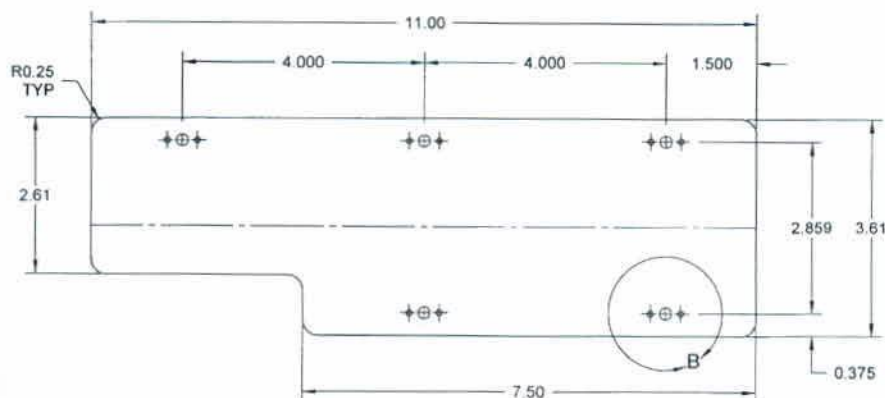
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WATER SUPPLY

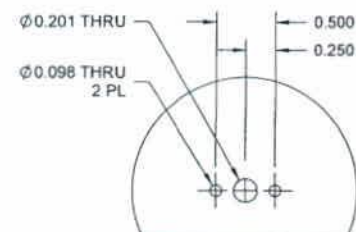
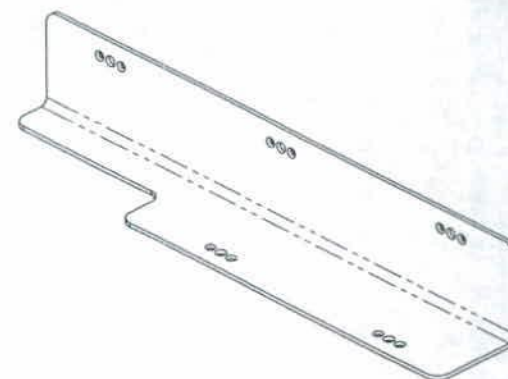
WATER SUPPLY



D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F



D3781-1F FLAT PATTERN



DETAIL B
SCALE 2X, 5 PL

UNDER REVIEW
09.01.14

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

RELEASED
09/01/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

40734

